

Date: Tuesday, 3/27/2007 10:10:12 AM  
 User: Eric Charbonneau

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	GUIDE ASSEMBLY
<b>Job Number</b> :	31462		
<b>Estimate Number</b> :	12709		
<b>P.O. Number</b> :	N/A	<b>Part Number</b> :	D3572041
<b>This Issue</b> :	3/27/2007	<b>S.O. No.</b> :	N/A
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3572 UNDER REVIEW
<b>First Issue</b> :	3/26/2007	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	30675	<b>Drawing Revision</b> :	U/R
		<b>Material</b> :	N/A
<b>Written By</b> :		<b>Due Date</b> :	4/2/2007
<b>Checked &amp; Approved By</b> :		<b>Qty:</b>	2 Um: Each
<b>Comment</b> :	Est Rev:A New Issue 07-02-07 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D35721	TUBE
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Comment: Qty.: 2.0000 (s)/Unit Total: 2.0000 (s)  
 GUIDE  
 Batch: N/A

2.0	D35727	CAP
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)  
 CAP  
 Batch: B31476

E 07.03.28 (2)

3.0	D35725	BRACKET
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
 BRACKET  
 Batch: B31477

E 07.03.28 (2)

4.0	MS21059L3	Nut Plate
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)  
 Nut Plate  
 batch: M101588

FF 07-03-27 (2)

5.0	MS20426AD33	Rivet
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)  
 Rivet  
M 7481

FF 07.03.27 (2)

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE ASSEMBLY

Job Number: 31462

Part Number: D3572041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

M6061T6TS0750W062

6061-T6 SQ Tube.75x.062W



Comment: Qty.: 2.3405 f(s)/Unit Total: 2.3405 f(s)

6061-T6 SQ Tube.75x.062W

Batch: M103069

EC 07.03.26

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

C'sink and rivet nut plates as per dwg

EC / SAB FF

07/03/26 (2)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut Tube to 26.75" as per Dwg D3572

EC 07.03.27

2-drill & mill per dwg D3572

EC 07.03.27

2-Weld as per Dwg D3572

A/R AL ROD

Batch: M100237

PG. 07.03.28 2

3-Grind welds for end caps.

PG. 07.03.28 2

9.0

QC5

INSPECT WORK TO CURRENT STEP

ENGINEERING  
APPROVAL



Comment: INSPECT WORK TO CURRENT STEP

UE 07.03.28

EC 07.03.28 (2)

10.0

QC9

VISUAL WELDING INSPECTION

ENGINEERING  
APPROVAL



Comment: VISUAL WELDING INSPECTION

UE 07.03.28

PG 07/03/28 (2)

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI-005 4.3

N/A

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Job Number: 31462

Part Number: D3572041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

FOR ENGINEERING USE ONLY

LE 07.03.29

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



LE 07.03.29

00064

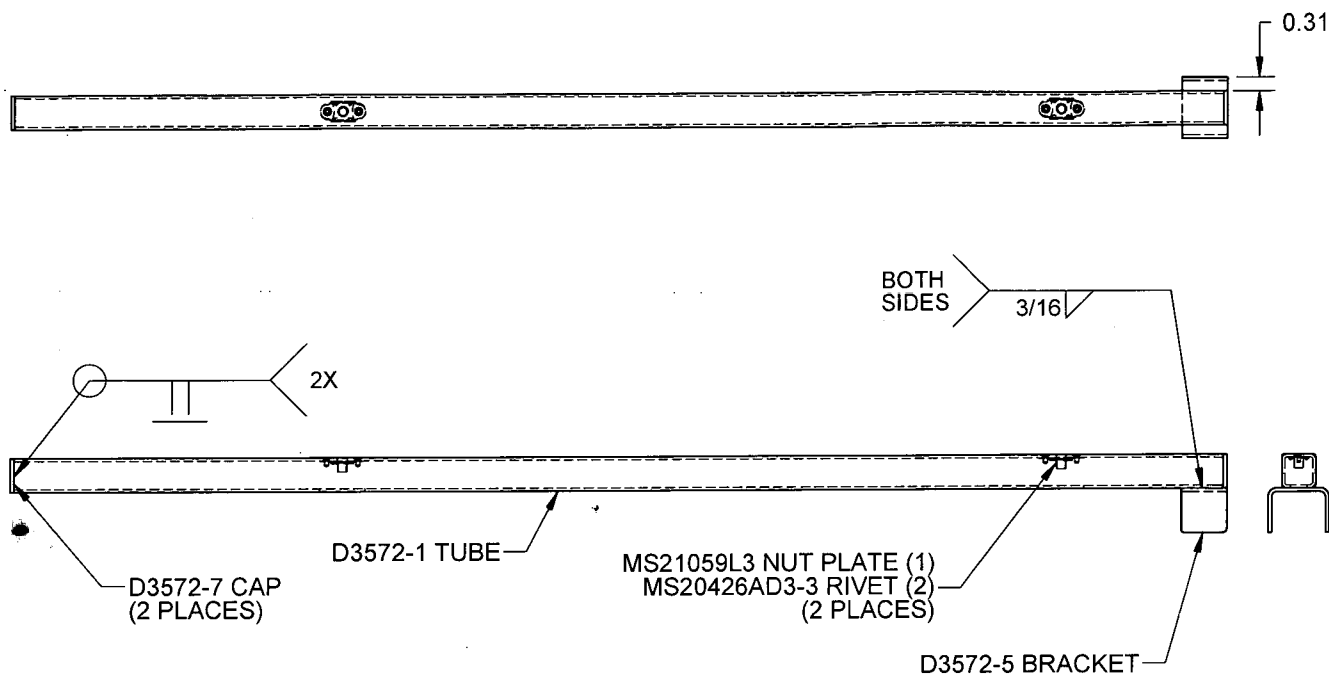
07/03/09

PRELIMINARY ISSUE

UNDER REVIEW

07.03.21 LE

DESIGN LE	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JB	APPROVED	DRAWING NO. D3572	REV. A SHEET 1 OF 2
DATE 07.03.15	TITLE GUIDE ASSEMBLY		SCALE 1:4
REV A	DATE 07.03.15	DESCRIPTION NEW ISSUE	



### D3572-041 GUIDE ASSEMBLY

#### D3572-041 PARTS LIST:

QTY	P/N	DESCRIPTION
X	D3572-041	GUIDE
1	D3572-1	TUBE
1	D3572-5	BRACKET
2	D3572-7	CAP
2	MS21059L3	NUT PLATE
4	MS20426AD3-3	RIVET

#### D3572-041 NOTES:

- 1) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) WELD PER DART QSI 004
- 4) IDENTIFY WITH DART P/N "D3572-041" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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